

Work Order ID 56891

March 12, 2010 10:14:33 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest Assembly

Start Date: 3/15/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-3-12* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3780	Rev D
-------	-------

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780
****torque screws as per dwg D3780****

sp. 10/05/13 (6)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sidostor

(46)

120

0.00



Identify as per dwg & Stock Location: *J61*

Packaging

Memo

0.00

Packaging

10-5-24 (6) SP

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56891

March 12, 2010 10:14:34 AM



Page 2

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest Assembly

Start Date: 3/15/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 AG
RL 10-5-17
(2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 10:14:30 AM

Page 1

Work Order ID: 56891

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/15/10

Required Date: 3/26/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3696-041		Manufactured	No			100	Each	8.0000	6.0000			



Arm Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST205

4

54819

4

Main Warehouse

ST255

4

56668

4

D3781-041

Manufactured No

100

Each

5.0000

6.0000



Lateral Cushion Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST185

5

47992

1

55171

4

D3781-043

Manufactured No

100

Each

1.0000

6.0000



Armrest Cushion Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST185

1

48436

1

B56902 (52)

B56650 (1x)

3/10/04/14
B56900 (20)

3/10/04/14
356901 (62)

3/10/04/14

W/O:			WORK ORDER CHANGES					
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Picklist Print

March 12, 2010 10:14:30 AM

Page 2

Work Order ID: 56891



Parent Item: D3780-041



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Start Date: 3/15/10

Required Date: 3/26/10

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------



Bracket

Manufactured

No

100

Each

6.0000

6.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST88

6

54826

6

100

Each

19.0000

6.0000

D3977-1



Bolt

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST105

19

55180

19

100

Each

19.0000

6.0000

D3978-1



Nut

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST105

19

55182

19

3/10/04/14
 356903 (4X)

2

3/10/04/14

6

3/10/04/14

6

March 12, 2010 10:14:30 AM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 3

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Parent Item Name: Armrest Assembly

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3979-1		Manufactured	No			100	Each	40.0000	6.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST105

40

51703

4

55183

36

AN960JD10L

Purchased

No

100

Each

3,029.000

12.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST348

3029

101291

16

105793

49

110985

2964

AN970-6

Purchased

No

100

Each

35.0000

12.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST349

35

10538

8

109798

27

March 12, 2010 10:14:30 AM

Shop Packet Print

Page 3

* QSI 017
 NAS1149D0332J
 M112794 (12x)

9510/04/14

6
 9510/04/14

9510/04/14

12

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 4

Work Order ID: 56891



Parent Item: D3780-041

Parent Item Name: Armrest Assembly

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
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 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			100	Each	2,289.000	12.0000			



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

2289

110844

35

111274

27

111668

58

112314

285

112385

164

113523

20

113537

700

113644

1000

Handwritten signature and date 3/10/04/14

MS24665-302

Purchased

No

100

Each

100.0000

6.0000



Cotter Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST309

100

111359

6

113644

94

Handwritten signature and date 3/10/04/14

March 12, 2010 10:14:31 AM

Shop Packet Print

Page 4

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March 12, 2010 10:14:31 AM

Page 5

Work Order ID: 56891

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 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/15/10

Required Date: 3/26/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24693-C272		Purchased	No			100	Each	1,392.000	12.0000			



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST310

1392

17137

519

17831

520

8814

3

8815

31

9063

19

9370

300

EB 10/04/14

9
3

MS24693-C277

Purchased

No

100

Each

62.0000

12.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST310

62

109297

12

113644

50

EB 10/04/14

4
8

March 12, 2010 10:14:32 AM

Shop Packet Print

Page 5

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 6

March 12, 2010 10:14:33 AM

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Parent Item Name: Armrest Assembly

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Required Date: 3/26/10

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 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
NAS1149D0663J		Purchased	No			100	Each	493.0000	6.0000			



Washer



Handwritten signature and date 3/10/04/14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST298

493

112612

193

113524

300

6

March 12, 2010 10:14:33 AM

Shop Packet Print

Page 6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

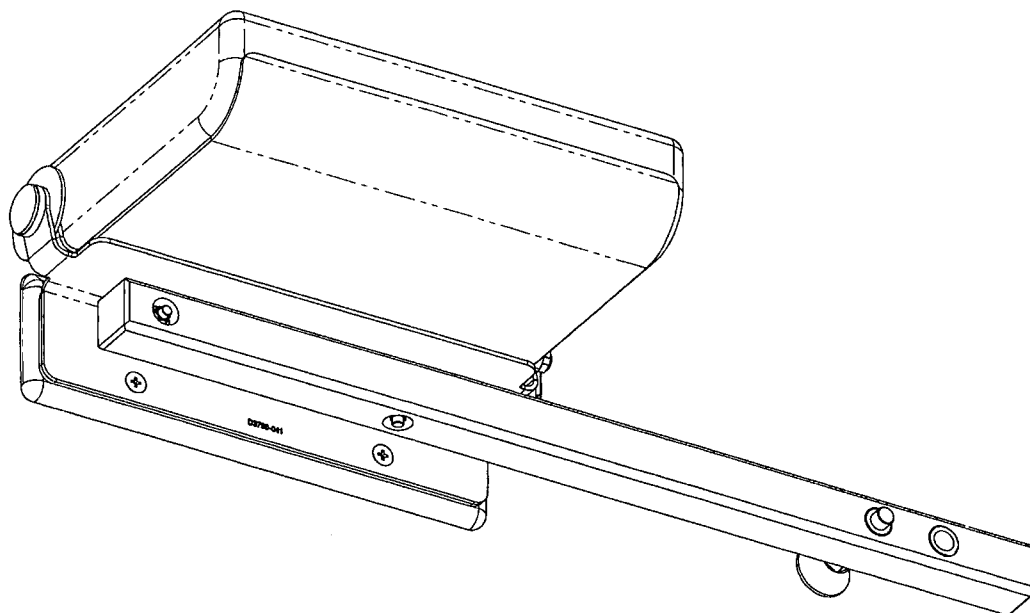
1

D

C

B

A



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3896-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 56821

2810-3-12

RELEASED
28/07/21 MP

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3780 REV. D TITLE ARMREST ASSEMBLY SCALE NTS SHEET 1 OF 3 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR SUBMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

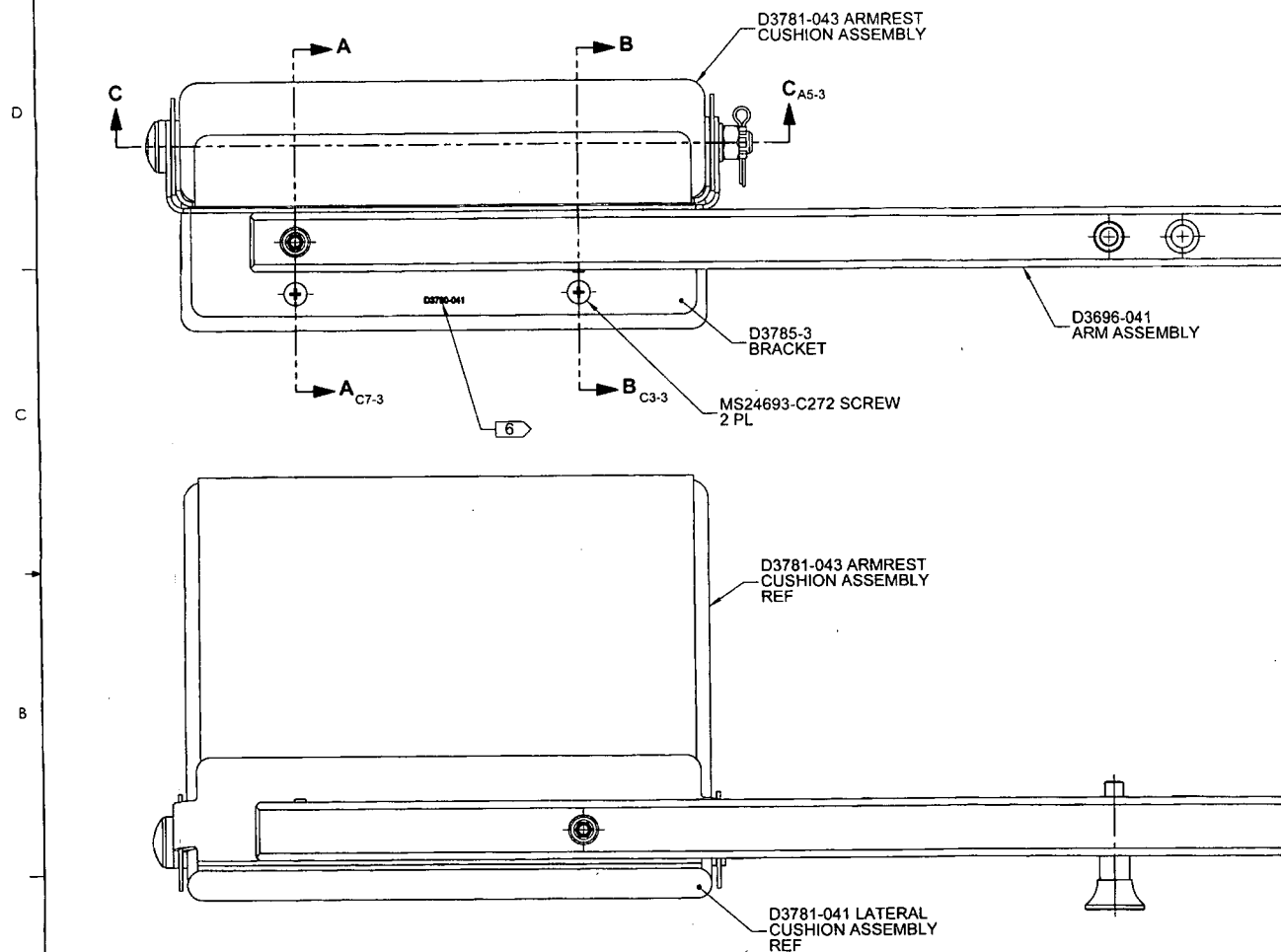
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56894
10-3-12

RELEASED
27/6/12

D3780-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 3.71 lbs
- 8) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540 OR AC43.13 CHAPTER 7-127

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

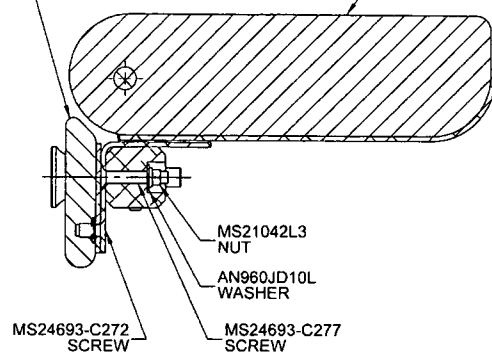
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D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF



SECTION A-A C7-2

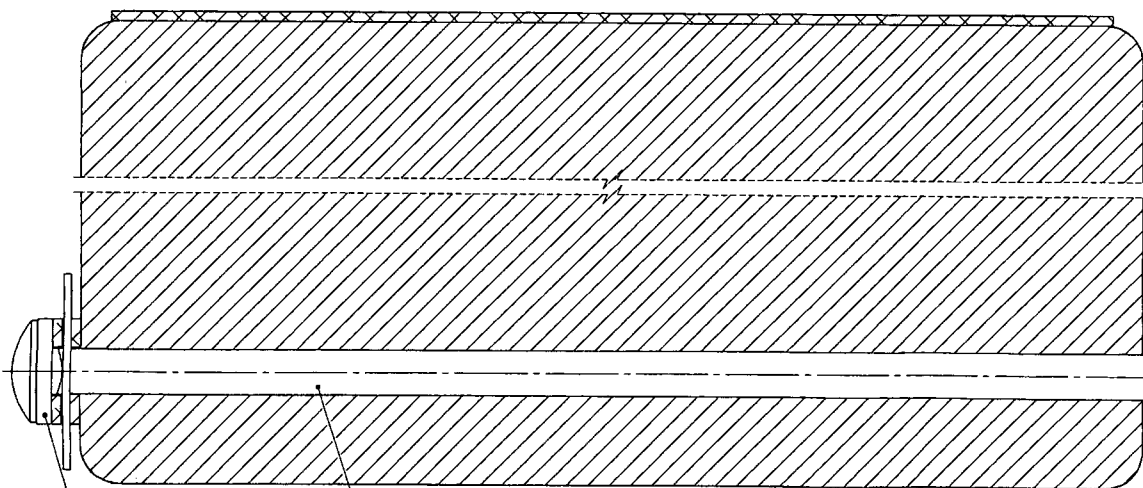
D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3785-3
BRACKET
REF
AN960JD10L
WASHER
MS21042L3
NUT
MS24693-C272
SCREW

SECTION B-B C6-2



SECTION C-C D5-2
SCALE: 2X

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3979-1 WASHER (SQUARE HOLE)

RELEASED
07/04/02

W/O 36891

DESIGN		DART AEROSPACE LTD	REV. D
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3780	SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		ARMREST ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	09.05.11	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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